Work Order ID 64540

Tuesday, December 07, 2010 2:57:57 PM

Item ID: D2648-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Wearpad

Start Date: 12/7/2010 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 12/21/2010 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** mf **Date:** 10-12-07 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D2648 / Rev D									
100	FLOW WATER JET	0.00				B11-1-3			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet 1010 ,063	1-Cut as per Dwg D2648□**********CUT WITH FILE D2648-1********** □Dwg Rev: D □Prog Rev: D □ 2-Deburr if necessary							7	
110	QC2- Inspect parts off machine FAI/FAIB	0.00				B11-1-3			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				(+7)			
QC	**Memo**	0.00 8 11/01/13							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	Deburr if necessary n/a S								
140	NC BRAKE	0.00				(7)			
Brake NC	**Memo**	0.00							
Brake NC	1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.□2-Identify as D2648-3 SB 10/01/03								
150	Large Fab	0.00							
Large Fab	**Memo**	0.00							
Large Fab	Qty Description Batch□A/R 560Hardcoat M 11 5552 Weld as per Dwg D2648 using Jig DT 8210□2-Remove any weld that penetrated through Wearpadif necessary					HB 11-1-18			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00 Satisfactory							
170 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 Satisfactory				7			
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 MM2588 **Memo** START TIME: 8:35 ☐OVEN TEMPERATURE: 390° ☐FINISH TIME: 9:05.	0.00 0.00				7			BR 11-8-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00	10/01/19			X7	0		
QC	**Memo**	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: FP-16	0.00				7 BR 11-01-19			
Packaging	**Memo**	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00					11/01/19		
QC	**Memo**	0.00							
Quality Control									

MF 11-01-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, December 07, 2010 2:57:57 PM

Work Order ID: 64540

Parent Item: D2648-3

Parent Item Name: Wearpad

Start Date: 12/7/2010 **Required Date:** 12/21/2010

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: E□02.09.18□Re-format; Incorporated D2648-1□KJ/RF
IPP Rev:F Now on Waterjet 06-08-14 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	84.5250	0.075	0.473684			
1010/1025 sheet 16GA													

1010

Location	Loc Qty	Loc Code
MAT19	84.525	
111410	84.525	

111410

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64540
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 **Rev:** D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.965	+/-0.010	1.966	~~1~~		V 1B02	
2.715	+/-0.010	2.715	~~1~~		V	
3.500	+/-0.010	3.500	~~1~~		V	
0.220 x 0.300	+/-0.010 x +/-0.010	.223 x .302	X		V	
R0.375	+/-0.010	.375	2		R.G.	
R0.128	+/-0.010	.128	2		R.G.	

Measured by:	HB
Date:	11-1-3

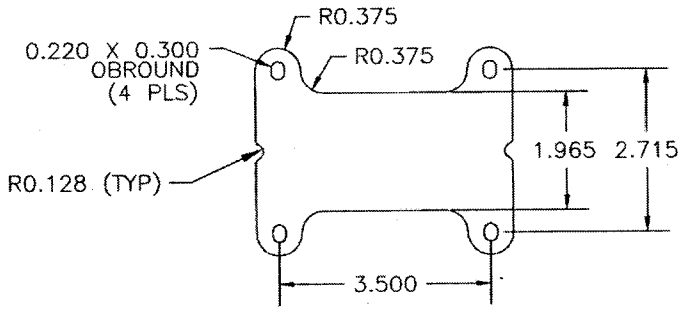
Audited by:	
Date:	11/01/03

Prototype Approval:	N/A
Date:	N/A

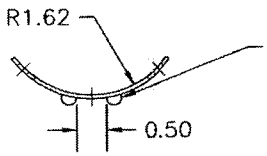
Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	

64540

D2648-1 FLAT PATTERN

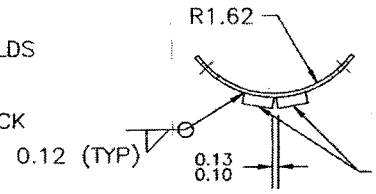


SECTION A-A



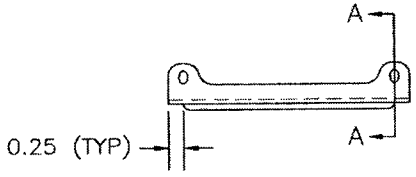
7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B

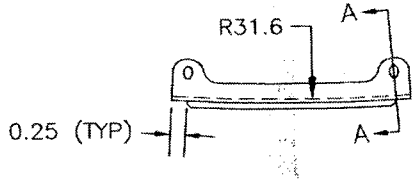


D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

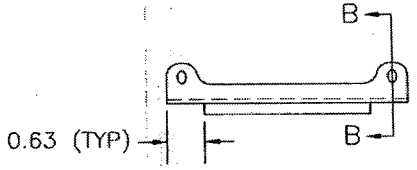
D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



RELEASED
11.12.20 DS

BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2648	REV. D
DATE 99.11.17		TITLE WEARPAD	SHEET 1 OF 1 SCALE 1:2

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